

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017009**Date Inspected:** 12-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

ZPMC CWI Inspector: Mr. Lv Li Qing

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Segment Trial Assembly

This QA Inspector observed ZPMC welder Mr. Wu Jun, stencil 053486 used flux cored welding procedure WPS-B-T-2231T to make weld OBW10L-005. This weld joins OBG segment 10BW counterweight attachment plate to the top deck plate. This QA Inspector observed a welding current of approximately 290 amps, 30.0 volts and Mr. Wu Jun appears to be certified to make this 4F weld. This QA Inspector observed the base materials appear to have been preheated with electric heating elements prior to welding. Items observed on this date appear to comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Chen Hong Ye, stencil 040270 used shielded metal arc procedure WPS-B-P-2112 to tack weld various "T" stiffener plates on the interior bottom plate and side plates at the weld joint between OBG segments 10BE and 10CE. Prior to making these welds, other ZPMC workers used mechanical jacks to align the ends of the "T" stiffener plates. This QA Inspector measured a welding current of approximately 170 amps, the base material was preheated with a torch and Mr. Chen Hong Ye appeared to be

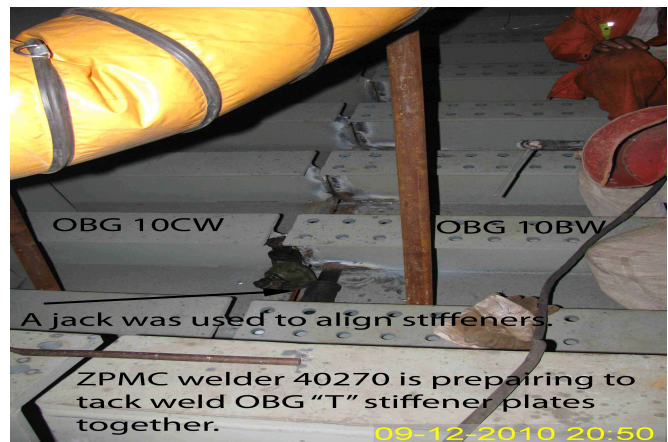
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certified to perform this welding. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.

This QA Inspector observed ZPMC welder Mr. Zhao Yong, stencil 046960 used shielded metal arc process to tack weld temporary alignment / jacking plates to the cross beam edge plates at the weld joints between OGB segments 10BE and 10CE. This QA Inspector observed a welding current of approximately 170 amps, the base material was preheated with a torch and Mr. Zhao Yong appeared to be certified to perform this welding. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Lv Gang Wei, stencil 053475 used shielded metal arc process to tack weld temporary hand rail posts to various locations on OGB segment 10BW the top deck plate. This QA Inspector measured a welding current of approximately 170 amps, the base material was preheated with a torch and Mr. Lv Gang Wei appeared to be certified to perform this welding. Items observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
